

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002040**Date Inspected:** 06-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Zhu Zhonghai
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** Tower Mock-Ups**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QA), M. Paul Stovall, was present at Zhenhua Port Machinery Company (Z. P. M. C.), Changxing Island, Shanghai, China for the purpose of monitoring the fabrication of the SAS/San Francisco/Oakland Bay Bridge.

77 meter Mock-Up, Z. P. M. C. Welder, Xue Yin--040634 was the welder. Certified Welding Inspector (CWI) is not present. Weld number MUA-MA1-D/F-15B, using Welding Procedure Specification WPS)-B-T-2221-C-U2b-S-1, was being welded. Z. P. M. C., Quality Control (QC) Department, was called at the request of QA Inspector for someone to act as an interpreter. (Eric) Xu Jun, and Li Wen Sheng, arrived at the shop. The QA Inspector informed them of the work that was being done, in the absence of the CWI. They immediately called an Inspector over to over see the work. Z. P. M. C. Inspector, Zhu Zhonghai, had welders grind the ends of weld passes, between passes of weld number MUSA-SA104-A/B-6. The QA Inspector checked the welding parameters, at separate times and recorded: 520 amps, 30.4 volts, and 693 amps, and 31.4 volts.

89-meter Mock-Up, Z. P. M. C. personnel placed heaters on weld number MUB-MA21-H/J-21, prior to welding. Z. P. M. C. Welders, Li Dong—066236, Liu Xie—066236, Gong Huaigang—037840, started welding the above mentioned weld number. The QA Inspector recorded the following measurements, at various times: 172 amps, 168 amps, and 166 amps. This is Skin B to the Diaphragm.

114-meter Mock-Up, heaters have been previously placed on Skin A to B, to preheat the material, so that weld number MUC-MA106-B/C-4B, can be welded. The welders will be: Bai Wen Ming—040434, Chong Chang cong—0503870. An Ultrasonic Test (UT) reject, weld repair was started at the end of the shift, the weld number is

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

MUC-MA107-B/C-4B, this is on the 114-meter (upper) Mock-Up. Chen Xi, of Z. P. M. C., QC is present and recording and inspecting the work that is being performed.

Summary of Conversations:

QA Inspector told (Eric) Xu Jun, and Li Wen Sheng, about there not being a CWI present while welding was being done, and the need for an interpreter to be present.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Stovall,Paul	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
